

Work Order ID 150633

Monday, August 29, 2016 2:51:20 PM

150633

Page 1

Item ID: D3137-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Washer

Start Date: 8/24/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: AUG 30 2016
QC: 9-89 Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1-Machine as per Folio FA471 and Dwg D3137
2-Identify as D3137-5
3-Deburr

10 ϕ DAS 49 9-89
16/09/12

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10 ϕ DAS 49 9-89
16/09/12

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

10 ϕ 16/09/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Environment ☐</td> <td style="width:12.5%;">No Re-verification ☐</td> <td style="width:12.5%;">Pressure/Forced ☐</td> <td style="width:12.5%;">Temperature/Cure ☐</td> <td style="width:12.5%;">Power Loss/Surge ☐</td> <td style="width:12.5%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4"></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td colspan="4" style="text-align: center;">OTHER : _____</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐					Misidentified ☐	Past Due ☐	OTHER : _____									
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Page 2

Item ID: D3137-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Washer

Start Date: 8/24/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

X10**✓**

2016/09/13

BEB

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

10WMS
38
9-89

SEP 13 2016

160

Identify as per dwg & Stock Location: **Stop**

0.00

160

Packaging

Memo

0.00

Packaging

10DAS
6
9-89

SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
68-4 SC								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Misidentified ☐	☐	Past Due ☐							

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Page 3

Item ID: D3137-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Washer
Start Date: 8/24/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00					DAS 21		SEP 13 2016
170							9-89		
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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200 100 50 25 12.5 6.25 3.125 1.5625 0.78125 0.390625 0.1953125 0.09765625 0.048828125 0.0244140625 0.01220703125 0.006103515625 0.0030517578125 0.00152587890625 0.000762939453125 0.0003814697265625 0.00019073486328125 0.000095367431640625 0.0000476837158203125 0.00002384185791015625 0.000011920928955078125 0.0000059604644775390625 0.00000298023223876953125 0.000001490116119384765625 0.0000007450580596923828125 0.00000037252902984619140625 0.000000186264514923095703125 0.0000000931322574615478515625 0.00000004656612873077392578125 0.000000023283064365386962890625 0.0000000116415321826934814453125 0.00000000582076609134674072265625 0.000000002910383045673370361328125 0.0000000014551915228366851806640625 0.00000000072759576141834259033203125 0.000000000363797880709171295166015625 0.0000000001818989403545856475830078125 0.00000000009094947017729282379150390625 0.000000000045474735088646411895751953125 0.0000000000227373675443232059478759765625 0.00000000001136868377216160297393798828125 0.000000000005684341886080801486968994140625 0.0000000000028421709430404007434844970703125 0.00000000000142108547152020037174224853515625 0.000000000000710542735760100185871124267578125 0.0000000000003552713678800500929355621337890625 0.00000000000017763568394002504646778106689453125 0.000000000000088817841970012523233890533447265625 0.0000000000000444089209850062616169452667236328125 0.00000000000002220446049250313080847263336181640625 0.000000000000011102230246251565404236316680908203125 0.0000000000000055511151231257827021181583340541015625 0.000000000000002775557561562891351059079167027053125 0.0000000000000013877787807814456755295395835135265625 0.00000000000000069388939039072283776476979175676328125 0.000000000000000346944695195361418882384895878381640625 0.0000000000000001734723475976807094411924479391908203125 0.00000000000000008673617379884035472059622396959541015625 0.0000000000000000433680868994201773602981119847977053125 0.00000000000000002168404344971008868014905599239885265625 0.000000000000000010842021724855044340074527996199426328125 0.0000000000000000054210108624275221700372639980997131640625 0.00000000000000000271050543121376108501863199904985658203125 0.000000000000000001355252715606880542509315999524928291015625 0.0000000000000000006776263578034402712546579997624641455078125 0.00000000000000000033881317890172013562732899988123207275390625 0.000000000000000000169406589450860067813664499940616036376953125 0.0000000000000000000847032947254300339068322499703080181884765625 0.00000000000000000004235164736271501695341612498515400909423828125 0.000000000000000000021175823681357508476708062492577004547119140625 0.0000000000000000000105879118406787542383540312462885022735595703125 0.00000000000000000000529395592033937711917701562311442513677978515625 0.000000000000000000002646977960169688559588507811557212568889892578125 0.0000000000000000000013234889800848442797942539057786062844449462890625 0.00000000000000000000066174449004242213989712695288930314222247314453125 0.000000000000000000000330872245021211069948563476444651571111236722265625 0.0000000000000000000001654361225106055349742817382223257855556183611328125 0.00000000000000000000008271806125530276748714086911116289277780918056640625 0.000000000000000000000041359030627651383743570434555581446388904590283203125 0.0000000000000000000000206795153138256918717852172777907231944522951416015625 0.00000000000000000000001033975765691284593589260863889536159722614757080078125 0.000000000000000000000005169878828456422967946304319447680798613073785400390625 0.0000000000000000000000025849394142282114839731521597238403993065368927001953125 0.00000000000000000000000129246970711410574198657607986192019965326844635009765625 0.000000000000000000000000646234853557052870993288039930960099826634223175048828125 0.0000000000000000000000003231174267785264354966440199654800499133171115875244140625 0.00000000000000000000000016155871338926321774832200998274002495665855579376220703125 0.000000000000000000000000080779356694631608874161004996370012478329277896881103515625 0.0000000000000000000000000403896783473158044370805024981850062391646389484405517578125 0.00000000000000000000000002019483917365790221854025124909250311958231947422027587890625 0.000000000000000000000000010097419586828951109270125624546250155979159737110137939453125 0.0000000000000000000000000050487097934144755546350628122731250779895798685550689697265625 0.00000000000000000000000000252435489670723777731753140613656250389947993427793448486328125 0.000000000000000000000000001262177448353618888658765703068281250194979967138967242431640625 0.0000000000000000000000000006310887241768094443293828515341406250097489983569336212158203125 0.00000000000000000000000000031554436208840472216469142576707031250048749494178168060791015625 0.000000000000000000000000000157772181044202361082345712883535156250024374747089080303955078125 0.000000000000000000000000000078886090522101180541172856441767578125001218737354454015197765625 0.0000000000000000000000000000394430452610505902705864282208837890625000609368672270075988828125 0.00000000000000000000000000001972152263052529513529321411044189453125000304693361350379944140625 0.000000000000000000000000000009860761315262647567646607055220947265625000152346680675189972265625 0.00000000000000000000000000000493038065763132378382330352761047363281250000761733403375949861328125 0.000000000000000000000000000002465190328815661891911651763805236816406250000380866701687974806640625 0.00000000000000000000000000000123259516440783094595582588190261840820312500001904333508439874033203125 0.0000000000000000000000000000006162975822039154729779129409513092041015625000009521667542199370166015625 0.00000000000000000000000000000030814879110195773648895647047565460205078125000004760833771099685080078125 0.000000000000000000000000000000154074395550978868244478235237827301025390625000002380416885549842540390625 0.00000000000000000000000000000007703719777548943412223911761891365051269531250000011902084427749212701953125 0.000000000000000000000000000000038518598887744717061119558809456825256347656250000005951042213874635009765625 0.000000000000000000000000000000019259299443872358530559779404728412628173828125000000297552110693731750390625 0.00000000000000000000000000000000962964972193617926527988970236420631408691406250000001487760553468658751953125 0.000000000000000000000000000000004814824860968089632639944851182103157043456250000000074388027673432937509765625 0.000000000000000000000000000000002407412430484044816319972425591051578521728125000000003719401383671646875048828125 0.0000000000000000000000000000000012037062152420224081599862127955257892608640625000000001859700691835823437502444140625 0.000000000000000000000000000000000601853107621011204079993106397762894630432031250000000092985034591791171875012220703125 0.00000000000000000000000000000000030092655381050560203999655319888144731521601562500000004649251729589558593750061103515625 0.0000000000000000000000000000000001504632769052528010199982765994407236576080078125000000232462586479477929687500305517578125 0.0000000000000000000000000000000000752316384526264005099991382999720368288040039062500000011623129323973896484375001527587890625 0.000000000000000000000000000000000037615819226313200254999569149986018414402001953125000000581156466198694824218750007637939453125 0.000000000000000000000000000000000018807909613156600127499784574993009207201000976562500000029057823309934741210937500038189697265625 0.0000000000000000000000000000000000094039548065783000637498922874996504603600500488281250000001452891165496737061046875000190948486328125 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Picklist Print

Monday, August 29, 2016 2:51:19 PM

Page 1

Work Order ID: 150633

150633

Parent Item: D3137-5

D3137-5

Parent Item Name: Washer

Start Date: 8/24/2016

Required Date: 8/29/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.11.04New issueKJ/JLM
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased		No		100	f	28.7300	0.0208	0.218947			

M6061T6R0 750

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

28.73

m134551

4.73

m135094

12

m135377

12

.23

DAS
49
9-89

16/09/12

DQA: _____ Date: _____



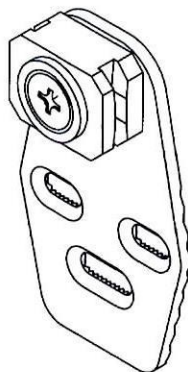
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

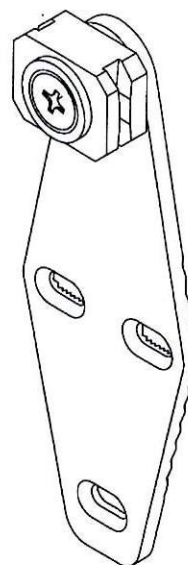
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

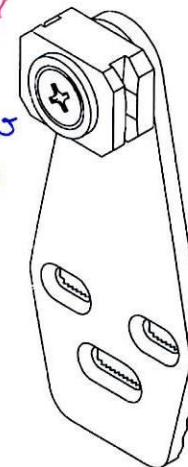
Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY

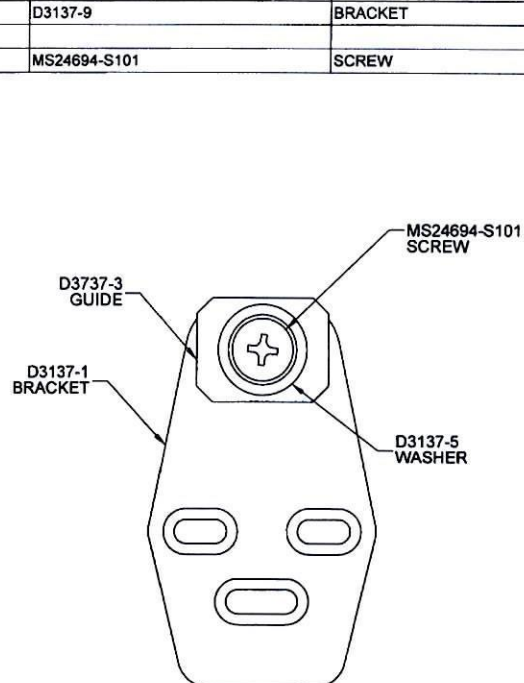


D3137-045 BRACKET ASSEMBLY

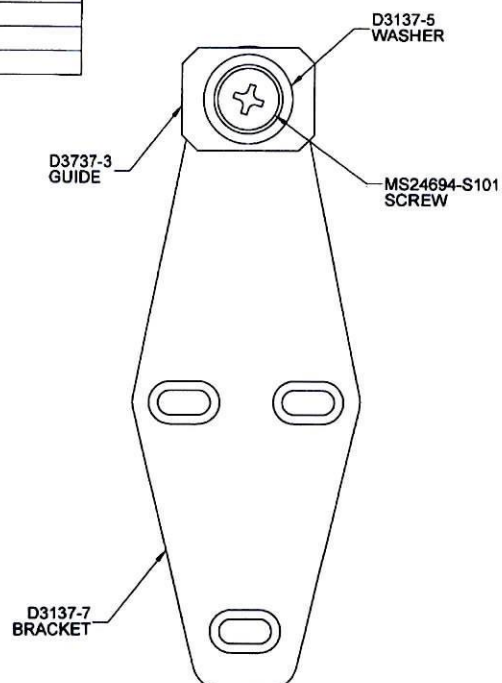
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150633 MWS
16-08-30

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.36 WAS 2.48, ZONE A 4 0.480 DIM WAS 0.605, ZONE A 8 0.67 DIM WAS 0.79, ZONE B 5 4.850 DIM WAS 4.975 & ZONE B8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3137 TITLE BRACKET ASSEMBLY SCALE NTS COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. F	SHEET 1 OF 5
DATE	08.05.30		

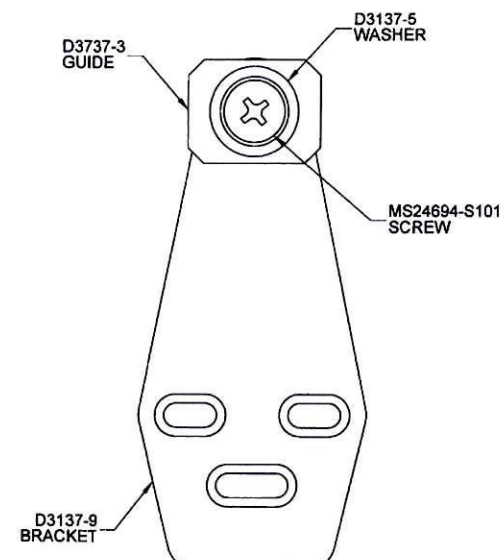
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



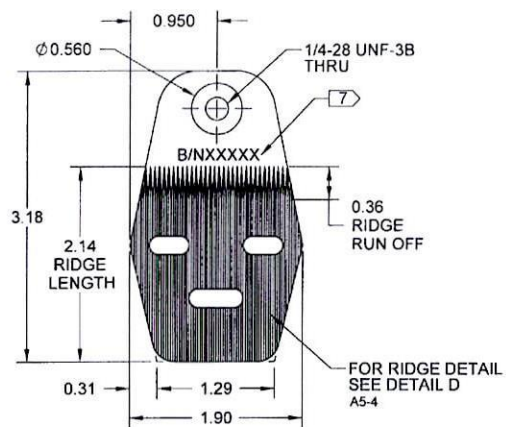
D3137-045 BRACKET ASSEMBLY

NOTES:

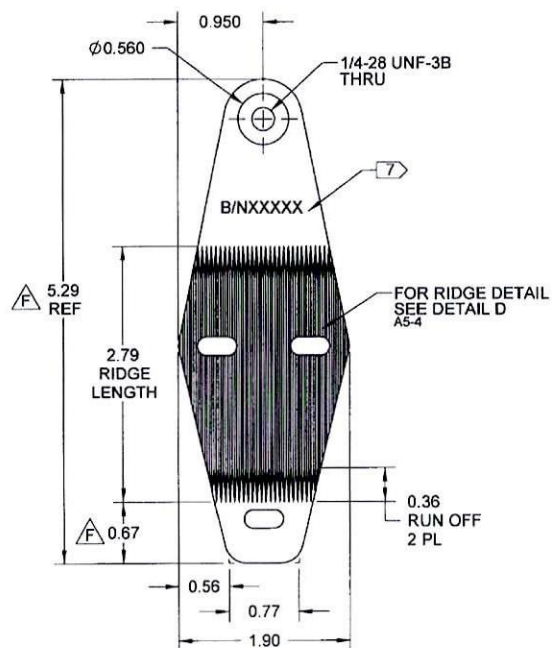
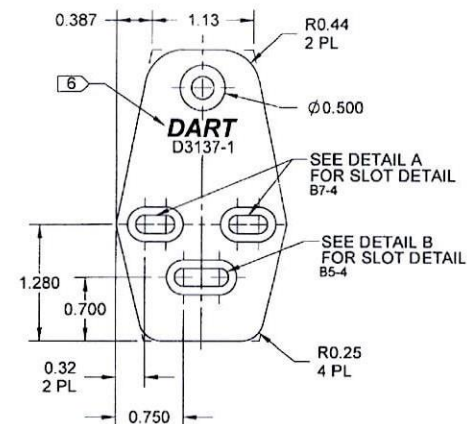
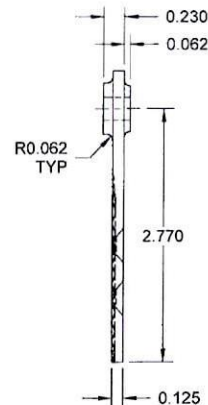
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

RELEASED
08-06-16/10

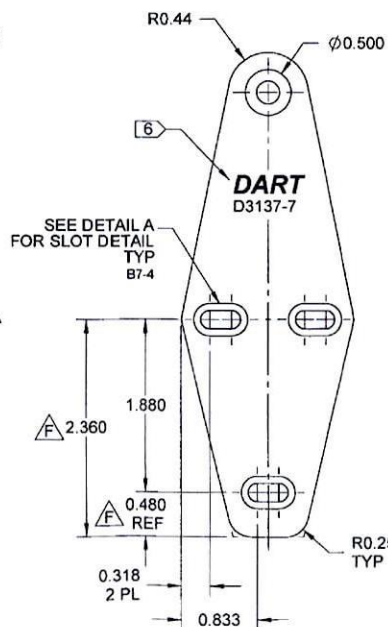
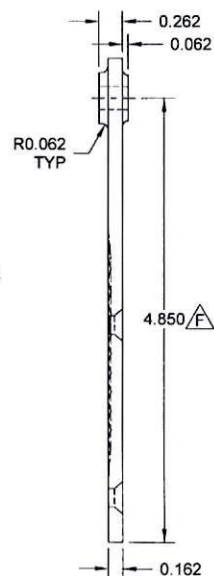
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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
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D3137-1 BRACKET



D3137-7 BRACKET

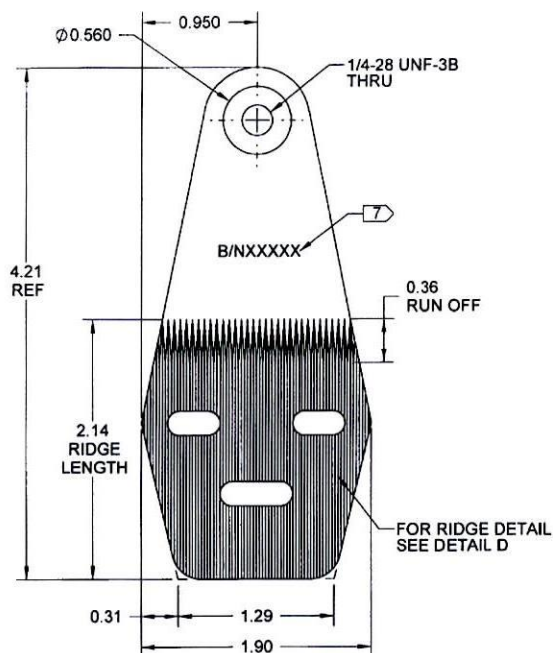


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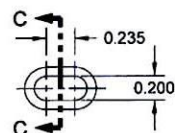
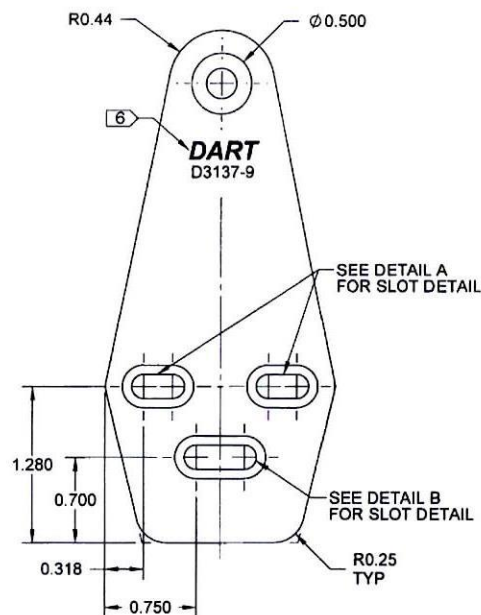
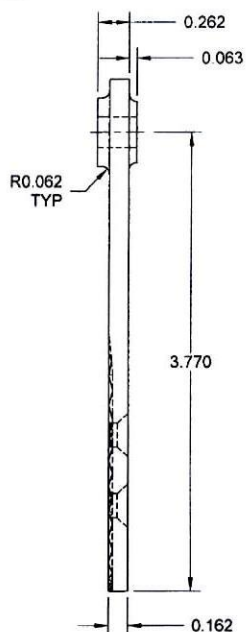
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

RELEASED
08.06.26 1/14

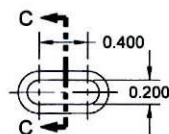
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3137	REV. F
MFG. APPR.		SHEET 3 OF 5	
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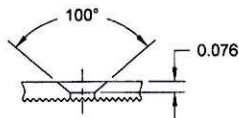
D3137-9 BRACKET



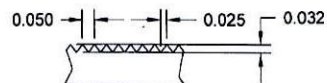
DETAIL A
(SLOT DETAIL)



DETAIL B
(SLOT DETAIL)



SECTION C-C
(SLOT DETAIL)



DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)

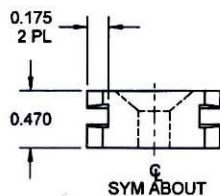
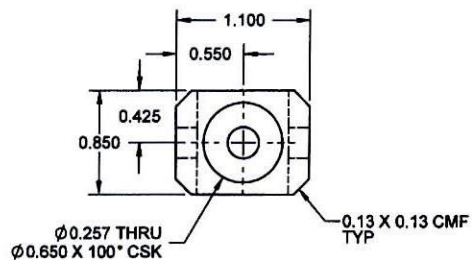
NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

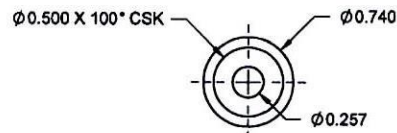
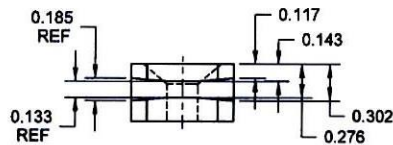
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
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08.06.30

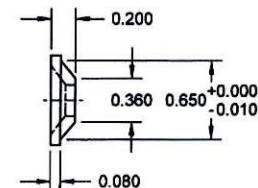
8 7 6 5 4 3 2 1



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELFIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELFIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED

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APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NT
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1